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RBW6405G04132-3G-4**Job Sheet 198024****Part No:** RBW6405G04132-3G-4**Job Qty:** 2 pcs**Part Name:** Frame Assembly**Part Weight:** 0 lbs**Status:** New**Priority:** Medium**Job Created:** 7/19/19**Job Tracking No:****Due Date:** 8/23/19**Created By:** Marie Lajeunesse**Type:** SOLD**Description:****Note:** DWG RBW6405G04132-3G Rev.E IPP Rev. A 19.03.08 New issue DP Verify DD**Ship Via:****Bill of Materials**

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Small Fab - 1	2 pcs	8/23/19	0.00	0.40	Small Fab - 1		G0 19-09-23	
						Small Fab - 2			
						Small Fab - 3			
						Small Fab - 4			
						Small Fab - 5			
						Small Fab - 6			
						Small Fab - 7			
110	QC 5	2 pcs	8/23/19	0.00	0.00	QC 5 - 10		DAS SEP 27 2019 40 9-89	
						QC 5 - 12			
						QC 5 - 17			
						QC 5 - 18			
						QC 5 - 19			
						QC 5 - 22			
						QC 5 - 24			
						QC 5 - 3			
						QC 5 - 43			
						QC 5 - 49			
						QC 5 - 51			
						QC 5 - 58			
						QC 5 - 68			
						QC 5 - 9			
						QC 5 - 50			
						QC 5 - 30			
						120	Packaging 3-1 - Stock - B4B		2 pcs
Packaging 3 - 2 - B4B									
Packaging 3 - 3 - B4B									
						Packaging 3 - 4 - B4B			
						Packaging 3 - 5 - B4B			
						Packaging 3 - 6 - B4B			
						Packaging 3 - 7 - B4B			
						Packaging 3 - 8 - B4B			
						Packaging 3 - 9 - B4B			
						Packaging 3 - 10 - B4B			
130	QC 21 - SA	2 pcs	8/23/19	0.00	0.00	QC 21 - SA - 21		DAS 21 9-89 SEP 30 2019	
						QC 21 - SA - 70			
						QC 21 - SA - 53			

Part Op 100 - Assemble as per DWG. See note 8 and 9.
 Descriptions: 110 - QC5- Inspect part completeness to step on W/O
 120 - Identify as per dwg & Stock Location:
 130 - QC21- Final Inspection - Work Order Release

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
3896T31	Ferule 1/16 X 3/8" - Aluminum 26	8 Ea (4 ea)	100-Small Fab - 1	5199293
90905A652	Split Ring Rnd.68 Od X Rnd.570 Id X .11 63	8 Ea (4 ea)	100-Small Fab - 1	5201183?
91131A071	Spherical Washer - 17/32 I.D. X 1-1/8 O.D. 49	2 Ea (1 ea)	100-Small Fab - 1	5201209
91131A072	Steel Black Oxide Leveling Female Washer for 1/2" Screw Size 51	2 Ea (1 ea)	100-Small Fab - 1	5201099
94191A550	Hex Nut 1/2-20 Unf (Mccarr) 56	2 Ea (1 ea)	100-Small Fab - 1	5201102
CL-2-C	Lanyard Wire ✓	2.6660 ft (1.333 ea)	100-Small Fab - 1	5190004
RBW6405G04132-3G-5 Frame	92F	2 pcs (1 ea)	100-Small Fab - 1	5209640
RBW6405G04132-3G-6 Rod	97	2 pcs (1 ea)	100-Small Fab - 1	IX 5169441
RBW6405G04132-3G-7 Slider	97	2 pcs (1 ea)	100-Small Fab - 1	5209688
RBW6405G04132-3G-8 Pin		4 pcs (2 ea)	100-Small Fab - 1	5209925
Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Small Fab - 1	3896T31	8	827	0
	90905A652	8	0	0
	91131A071	2	0	0
	91131A072	2	0	0
	94191A550	2	0	0
	CL-2-C	3	1,203	0
	RBW6405G04132-3G-5	2	0	0
	RBW6405G04132-3G-6	2	1	0
	RBW6405G04132-3G-7	2	0	0
	RBW6405G04132-3G-8	4	0	0
Part Specifications				
Specifications could not be found.				

Plex 7/19/19 2:33 PM Dart.lajeunesse.marie



Container No: S217962



Part: RBW6405G04132-3G-4

Job No: 198024

Serial No/Batch: S217962

Revision: E

Inspector:

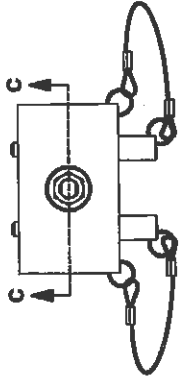
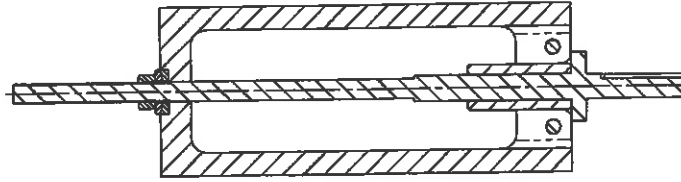
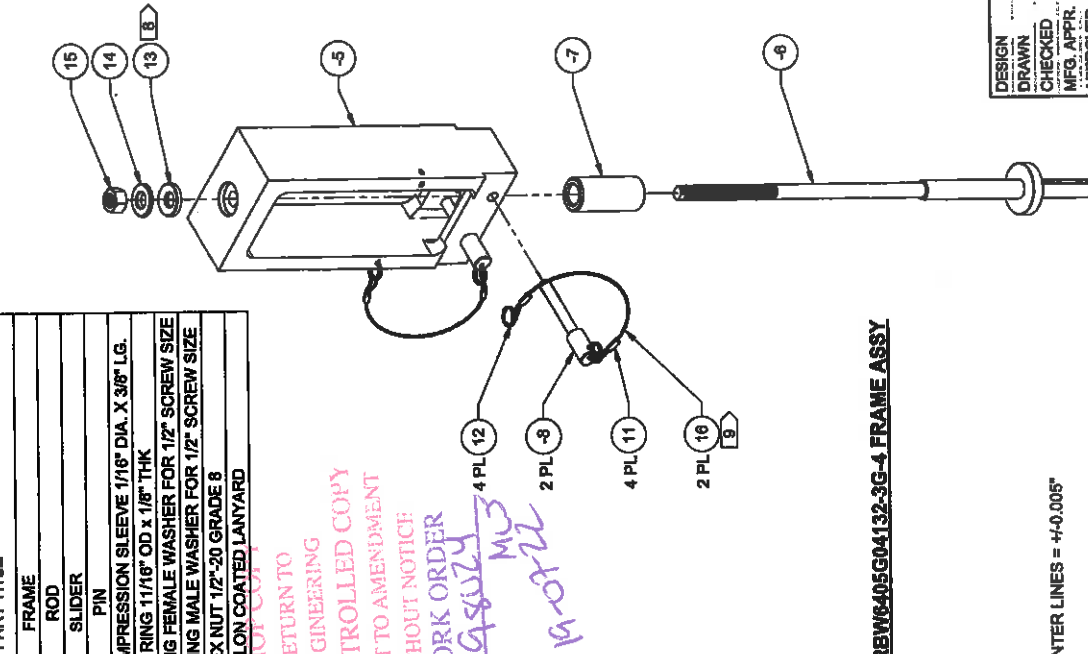
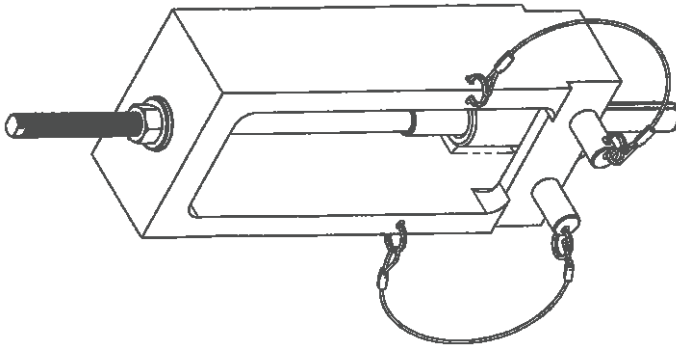
Exp Date:

Instructions:

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www.dartaerospace.com

Date: 09/27/19

ITEM #	QTY	PART #	PART TITLE
-5	1	RBW6405G04132-3G-5	FRAME
-6	1	RBW6405G04132-3G-6	ROD
-7	1	RBW6405G04132-3G-7	SLIDER
-8	2	RBW6405G04132-3G-8	PIN
11	4	McMaster#3988731 OR EQUIV.	ALUMINUM WIRE ROPE COMPRESSION SLEEVE 1/16" DIA. X 3/8" L.G.
12	4	McMaster#909054852 OR EQUIV	SS316 SPLIT RING 1 1/16" OD x 1/8" THK
13	1	McMaster#91131A072 OR EQUIV	STEEL BLACK OXIDE LEVELING FEMALE WASHER FOR 1/2" SCREW SIZE
14	1	McMaster#91131A071 OR EQUIV	STEEL BLACK OXIDE LEVELING MALE WASHER FOR 1/2" SCREW SIZE
15	1	McMaster#94191A850 OR EQUIV	STEEL HEX NUT 1/2"-20 GRADE 8
16	AR	CL-2-C	STEEL NYLON COATED LANYARD



RBW6405G04132-3G-4 FRAME ASSY

NOTES:
1) MATERIAL: N/A
2) HEAT TREAT: N/A
3) FINISH: N/A
4) TOLERANCES: X.X = $\pm 0.1"$ / $\pm 1"$
X.XX = $\pm 0.01"$ / $\pm 0.5"$
X.XXX = $\pm 0.005"$ / $\pm 0.1"$
X.XXXX = $\pm 0.0005"$ / $\pm 0.05"$

PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = $\pm 0.005"$
UNLESS OTHERWISE NOTED
UNITS: INCHES UNLESS SHOWN
ASSEMBLY: N/A
6) IDENTIFICATION: N/A
7) APPLY RETAINING COMPOUND LOCTITE 620 OR EQUIVALENT ON MATING SURFACES
8) THEN PRESS FIT ITEM 13 WITH ITEM -5, AND REMOVE EXCESS
9) ASSEMBLED LANYARD LENGTH MUST BE 8" $\pm 1"$

DESIGN DRAWN	VM	DATE 3/11/2019
CHECKED	VM	
MFG. APPR.	VM	
APPROVED	RG	
TOOL PART # RBW6405G04132-3G		
TITLE T/R DUPLEX BEARING INSTALLATION NTS		
SHEET 5 OF 9		
SCALE		
REV. E		
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		

RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 19-8024
19-07-22



Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

Route update only ☐

NCR No. _____

Job: _____		DISPOSITION		DEPARTMENT/PROCESS				MRB (QSI042)			
Part No. _____		Rework Scrap Use-as-is		Skid-tube Machining Large Fab		Cross tube Small Fab Finishing		Eng. (Non-AW) Prod. Eng. Coord. Rec/Store/Packaging		Engineering Water Jet Supplier Quality	
Date: _____		Sequence #: _____		QTY Affected: _____		Disposition					
Description Work Order Deviation		Completed By									
		Lead hand / Supervisor									
		QC / QA Coordinator									
Root Cause		FAULT CATEGORY									
Operator Manufacturing Process Equip/Tooling Handling/Preservation Material Product Improvement Process Improvement Human Factors		Pressure/Forced Bending Crushing Cracks Crimp/kink/Ripple/Wave/Twist Marks/Chatter Mislabeled		Contamination Misaligned/off center BOM/Route Broken/Damage/Defect Incomplete/Unclear Instructions Drill Holes Fit/Function		Power Loss/Surge Folio/Program Grain Direction Weld Wrong Stock Pulled Out of Sequence Off-set/Set-up		Positioned Wrong Outside Tolerance Drawing Finish Part Lost/Missing Misread			
Other/Details:											